

Work Order ID 101982

May-22-13 7:19:31 AM

Black Smiley

101982

Page 1

Item ID: D3914-041 Accept

Revision ID:

Item Name: Long Basket Lid Assembly (350)

Start Date: 5/22/13 Start Qty: 1.00 *1*

Required Date: 6/06/13 Req'd Qty: 1.00 *1*

Reference:

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: *V* Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3914	pc1
D4020	A

100 Weld per dwg A/R S.S. rod Batch: *B12486* 0.00
Large Fab

100

Large Fab

Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A

2- weld hinge (3) and Mounting brackets as per dwg D3914

Visual inspect before welding mesh

3- tack weld mesh on basket as per dwg D3914

Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid; check with label plate before tacking mesh

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo 0.00

(ix) CC 13-5-23

13-05-27

*(DAS)
09
2-83*

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Item ID: D3914-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Long Basket Lid Assembly (350)

Start Date: 5/22/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat***								
	Start Time: 7:40								
	Oven Temperature: 320°F								
	Finish Time: 8:10								
140	Wing Walk as per dwg QSI005 4.4 Batch 175314	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								
	2- Install placard and label as per dwg								
	Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label								

1X mf 13/05/27

1 φ BR 13-5-27

W123480

DAS
09
89

Work Order ID 101982

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Item ID: D3914-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 5/22/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 6/06/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
160 *160* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00							
170 *170* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							

SAV
27
13-528

101980

1 0 13-5-28

13/5/28

MCS 13-05-28

Picklist Print

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Page 1

Work Order ID: 101982

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD VERF:JLM
IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 Mounting Bracket		Manufactured	No			100	Each	66.0000	2	2		CC 13-5-22	

Location	Loc Qty	Loc Code
WA	10	
98503	10	
WA004	56	
101383	20	
70766	2	
81253	1	
82506	2	
83230	3	
85452	2	
87706	2	
99067	12	
99837	12	

D2728-3
Dart Logo label

Manufactured No

140 Each 0.0000

0 0

6/2 13-5-22

D3914-1
Rib

Manufactured No

100 Each 10.0000

2 2

CC 13-5-22

Location	Loc Qty	Loc Code
WA004	2	
88645	2	
WA005	8	
81449	1	
82131	1	
87079	1	
97659	4	
97660	1	

2X

Picklist Print

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Work Order ID: 101982

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D3914-7 Manufactured No 100 Each 9.0000

2 2 CC 13-5-22

Location	Loc Qty	Loc Code
WA005	9	
82928	3	
88649	1	
97706	4	
97949	1	

(2x)

D4016-3 Manufactured No 100 Each 48.0000

3 3 CC 13-5-22

Location	Loc Qty	Loc Code
WA004	48	
100203	2	
101043	20	
94755	8	
95563	18	

(2x)

(1x)

D4018-5 Manufactured No 100 Each 36.0000

9 9 CC 13-5-22

Location	Loc Qty	Loc Code
WA	9	
88680	9	
WA004	27	
97692	27	

(9x)

D4020-5 Manufactured No 100 Each 4.0000

1 1 CC 13-5-22

Location	Loc Qty	Loc Code
WA007	4	
96611	1	
99719	3	

(1x)

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Shop Packet Print

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Picklist Print

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Work Order ID: 101982

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/22/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

D4021-3
Data Plate

Manufactured No

100 Each 68.0000

1 1 CC 13-5-22

Location

Loc Qty

Loc Code

WA004

68

101346

54

80897

9

82507

1

88510

4

D4035-041

Manufactured No

100 Each 0.0000

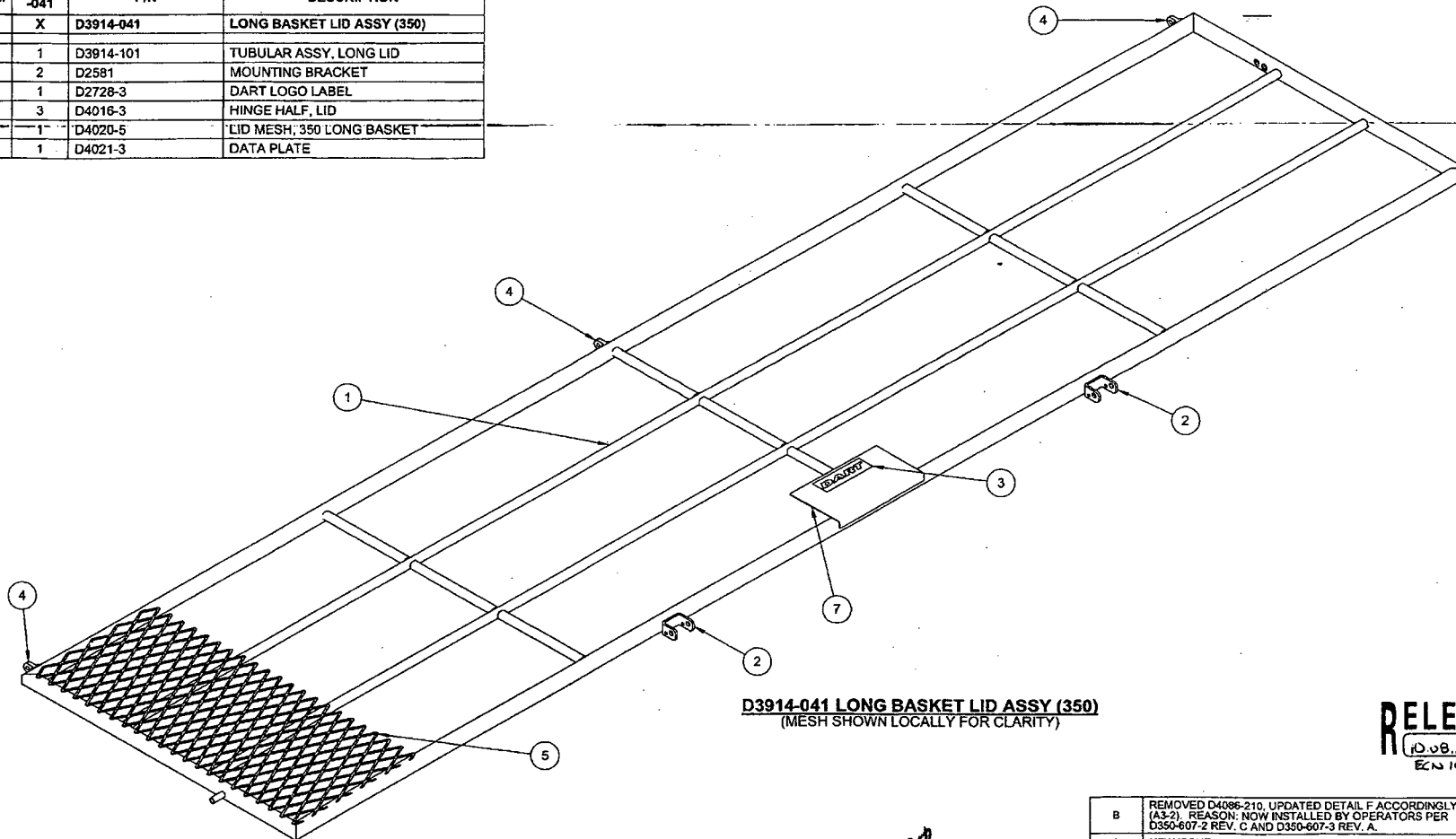
2 2 CC 13-5-22

Lid Rib Assembly, Fwd (350 Basket)

B98423 → (X1)

* D4035-043 — B97686 → (X1) CC 13-5-22

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

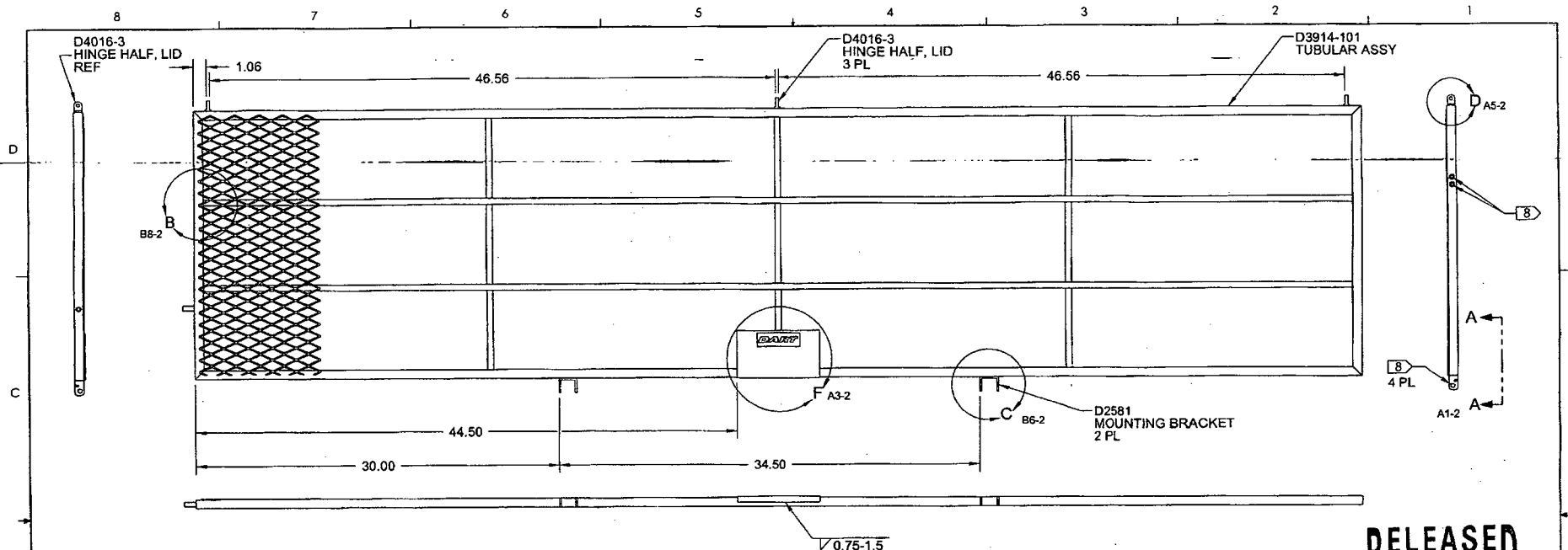


D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

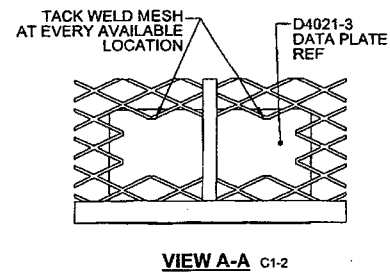
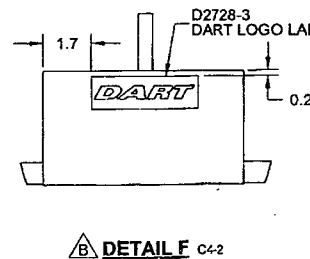
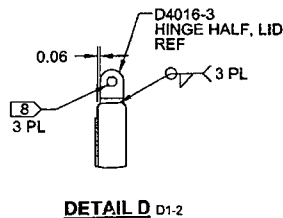
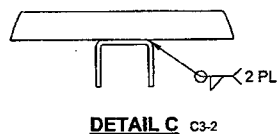
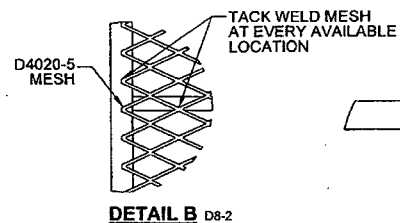
w/o 101982

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	ALS		
APPROVED	ALS		
DE APPR.	ALS		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			
		REV. B	SCALE NTS
		SHEET 1 OF 4	



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



RELEASED
10-08-12 up

NOTES:

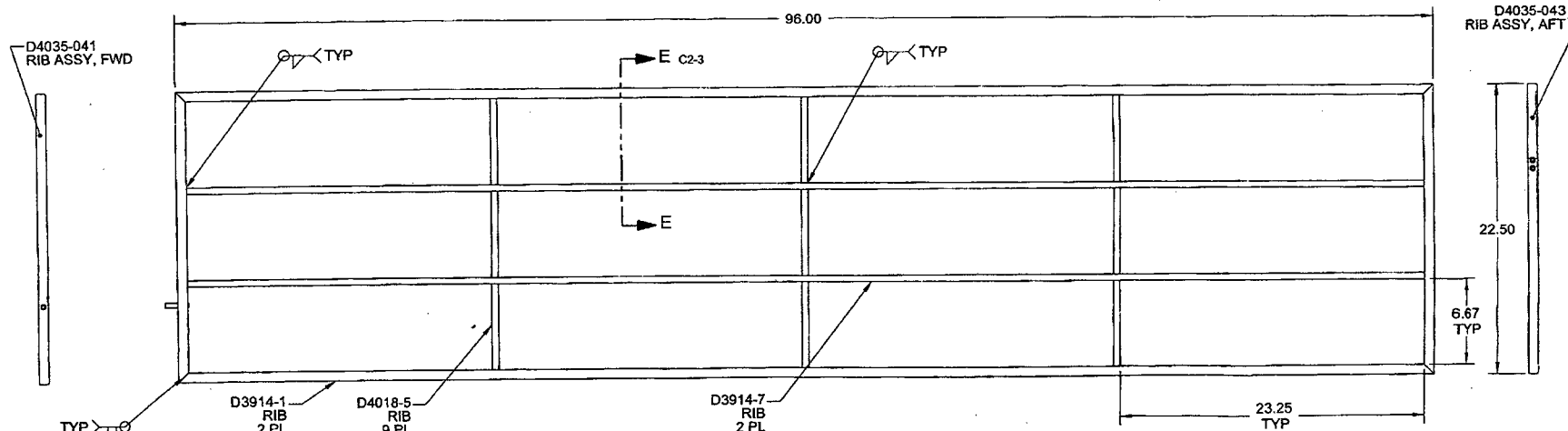
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	WJ	DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

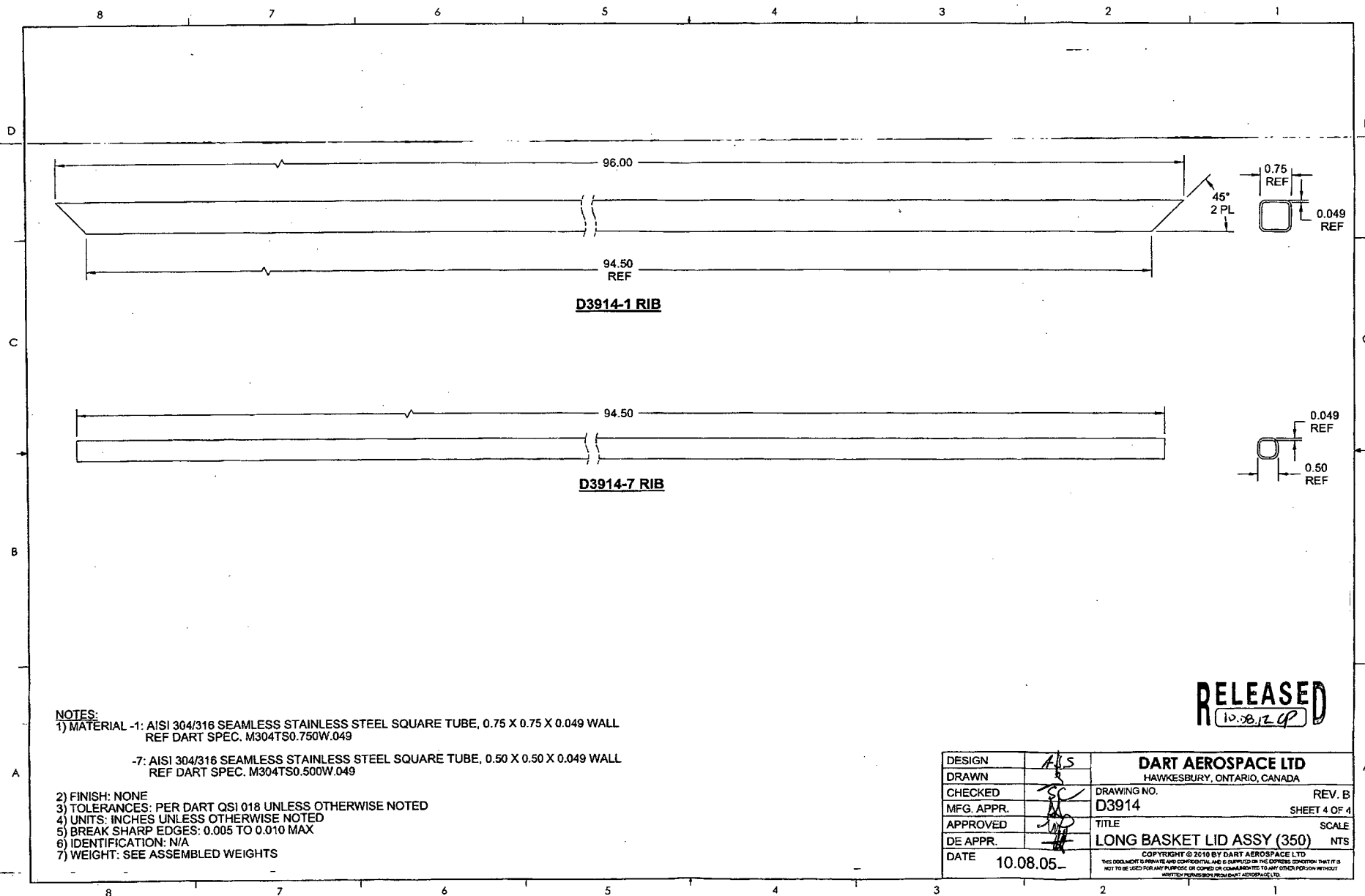
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10-08-12

NOTES:

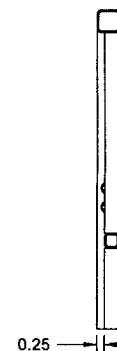
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO. D3914	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 4
APPROVED		LONG BASKET LID ASSY (350)	SCALE NTS
DE APPR.			
DATE	10.08.05		

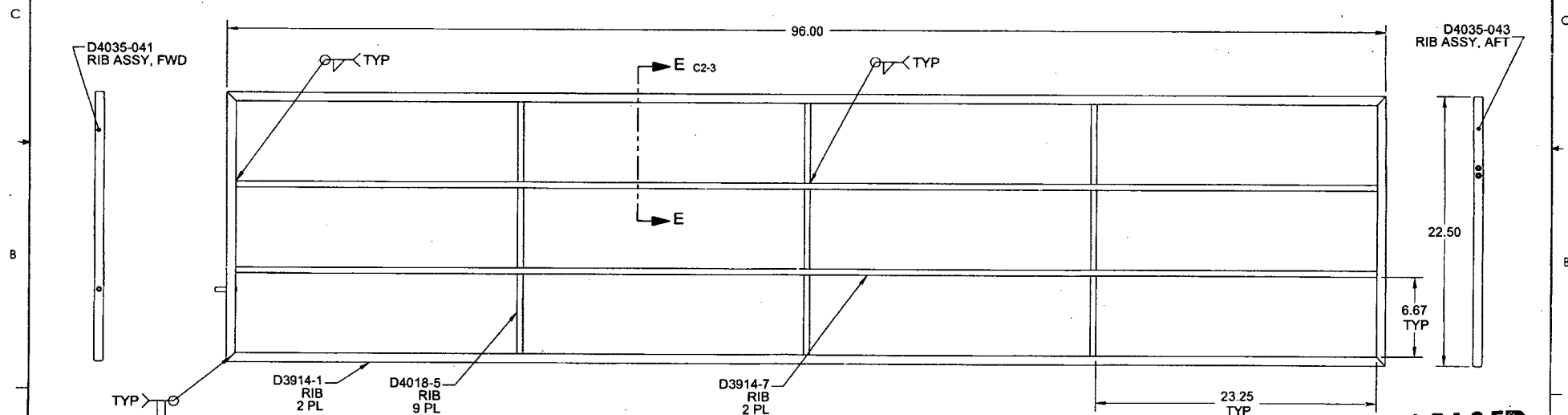
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3







8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

RELEASED
2010-03-22
AJP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3914	REV. A
MFG. APPR.		SHEET 3 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	
DATE	10.03.16	NTS	
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